



Dart Hawkesbury
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

D4634-143
Job Sheet 167077-G



Part No: D4634-143

Job Qty: 1 ea

Part Name: Middle, Center Ceiling Replacement Panel Assembly



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 10/24/17

Job Tracking No:

Due Date: 11/10/17

Created By: Mario Poulin

Type: SOLD

Description:

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier	
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time
90	Start up Operation	1 Ea		11/9/17	0.00	0.00	Start up container	2017-12-14 JSL
100	HandThermo	1 pcs		11/9/17	0.00	1.65	HandFinish4	17/12/17 JSL
110	Small Fab	1 pcs		11/10/17	0.00	1.47	Small Fab	17/12/17 JSL
120	QC	1 pcs		11/10/17	0.00	0.00	QC5	DEC 27 2017
130	Packaging	1 pcs		11/10/17	0.00	0.00	Packaging3	DEC 27 2017
140	QC21-SA	1 Ea		11/10/17	0.00	0.00	QC21	DEC 27 2017

Part Op 100 - Pick Kit

Descriptions: 110 - Assemble as per Dwg D4634-143 Bond foam core to inside of panel 3M Scotch Weld 1300

Batch: _____ 1- Scuff bonding surface to eliminate in-perfections and increase bonding and clean with wash& wipe 2- Locate and glue down Channel Assy, angles, brackets, and mounting pads using 3M Plastic welder II.(see note 8) Batch # _____ Expiry Date 12/04/15 3- Apply labels as per Dwg. and seal with 3M

3950 edge sealer(see note 9) Batch: 135435

120 - QC5- Inspect part completeness to step on W/O

130 - Identify as per dwg & Stock Location: _____

140 - QC21- Final Inspection - Work Order Release

Job Allocations

Operation	Component Part	Required	Inventory	Allocated	Std Qty
90-Start up Operation	- D4634-3 <u>5021868</u>	1	2	0	0
	- D4636-5 <u>5021867</u>	2	43	0	0
	- D4647-1 <u>5021866</u>	1	4	0	0
	- D4664-5 <u>5021865</u>	6	39	0	0
	- D4712-1 <u>5021863</u>	2	4	0	0
	- D4732-21 <u>5021858</u>	1	6	0	0
	- D4732-25 <u>5021842</u>	1	7	0	0
	- D5021-3 <u>5021841</u>	1	2	0	0
	- MPNY-750S-9-C <u>5021839</u>	3	570	0	0
	- MS20426AD3-4 <u>5021836</u>	4	5,055	0	0
	- MS20426AD4-6 <u>5021834</u>	4	2,797	0	0
	- MS21059L08 <u>5021833</u>	2	62	0	0

Part Specifications

Specifications could not be found.

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____ Date: _____ Des: _____		Dart Aerospace Ltd. 1270 Aberdeen Street Hawkesbury, ON K64 1K7 CANADA TEL: 1 613 632-5200 Email: sales@dartaero.com www.dartaerospace.com		Start up Operation Mfg Date: 12/14/17 Job No: 167077 - G		AGAINST DEPARTMENT/PROCESS <table border="1" style="width: 100%; border-collapse: collapse;"> <tr> <td style="width: 15%;">-tube</td><td>☐</td> <td style="width: 15%;">Cross tube</td><td>☐</td> <td style="width: 15%;">Water Jet</td><td>☐</td> <td style="width: 15%;">Engineering</td><td>☐</td> </tr> <tr> <td>ining</td><td>☐</td> <td>Small Fab</td><td>☐</td> <td>Prod. Eng. Coord.</td><td>☐</td> <td>Quality</td><td>☐</td> </tr> <tr> <td>rmg</td><td>☐</td> <td>Finishing</td><td>☐</td> <td>Rec/Store/Packaging</td><td>☐</td> <td>Other</td><td>☐</td> </tr> <tr> <td>e Fab</td><td>☐</td> <td>Composite</td><td>☐</td> <td>Supplier</td><td>☐</td> <td></td><td></td> </tr> </table>				-tube	☐	Cross tube	☐	Water Jet	☐	Engineering	☐	ining	☐	Small Fab	☐	Prod. Eng. Coord.	☐	Quality	☐	rmg	☐	Finishing	☐	Rec/Store/Packaging	☐	Other	☐	e Fab	☐	Composite	☐	Supplier	☐		
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						Lead hand / Supervisor Approval Verification																																			
						QC / QA Coordinator Approval																																			

Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐		DART AEROSPACE S021900 Middle, Center Ceiling Replacement Panel Assembly		PART NO: D4634 - 143 Revision: Operation: Change No:		FAULT CATEGORY <table border="1" style="width: 100%; border-collapse: collapse;"> <tr> <td style="width: 30%;">ure/Cure</td><td>☐</td> <td style="width: 30%;">Power Loss/Surge</td><td>☐</td> <td style="width: 30%;">Positioned Wrong</td><td>☐</td> </tr> <tr> <td>ite</td><td>☐</td> <td>Folio/Program</td><td>☐</td> <td>Outside Dimensions</td><td>☐</td> </tr> <tr> <td>amage/Defect</td><td>☐</td> <td>Grain</td><td>☐</td> <td>Over/Under tolerance</td><td>☐</td> </tr> <tr> <td>n Incomplete/Unqualified</td><td>☐</td> <td>Weld</td><td>☐</td> <td>Part Incorrect</td><td>☐</td> </tr> <tr> <td>nation</td><td>☐</td> <td>Wrong Stock Pulled</td><td>☐</td> <td>Part Lost/Missing</td><td>☐</td> </tr> <tr> <td>sink</td><td>☐</td> <td>Out of Sequence</td><td>☐</td> <td>Part Moved</td><td>☐</td> </tr> <tr> <td>Short</td><td>☐</td> <td>Off-set</td><td>☐</td> <td>Drawing</td><td>☐</td> </tr> <tr> <td>ions Incomplete/Unclear</td><td>☐</td> <td>Mislabeled</td><td>☐</td> <td>Finish</td><td>☐</td> </tr> <tr> <td></td><td>☐</td> <td>Fit/Function</td><td>☐</td> <td>Misread</td><td>☐</td> </tr> <tr> <td></td><td>☐</td> <td>Misaligned/off center</td><td>☐</td> <td>Turning Sequence</td><td>☐</td> </tr> </table>				ure/Cure	☐	Power Loss/Surge	☐	Positioned Wrong	☐	ite	☐	Folio/Program	☐	Outside Dimensions	☐	amage/Defect	☐	Grain	☐	Over/Under tolerance	☐	n Incomplete/Unqualified	☐	Weld	☐	Part Incorrect	☐	nation	☐	Wrong Stock Pulled	☐	Part Lost/Missing	☐	sink	☐	Out of Sequence	☐	Part Moved	☐	Short	☐	Off-set	☐	Drawing	☐	ions Incomplete/Unclear	☐	Mislabeled	☐	Finish	☐		☐	Fit/Function	☐	Misread	☐		☐	Misaligned/off center	☐	Turning Sequence	☐
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